

# DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D212-664 Rev. F AND  
INSTRUCTIONS FOR CONTINUOUS AIRWORTHINESS ICA-D212-664 Rev. 6

REF. CANADIAN STC: SH01-9

REF. FAA STC: SR01298NY

REF. EASA STC: EASA.IM.R.S.01304

For D212-664-101/-201 High Fwd/Aft Crosstube at CHG 004 or later, and D412-664-203 Aft Crosstubes at CHG 007 or later, an inspection window has been added on the underside of the crosstube to facilitate inspection.

**IMPORTANT NOTE:** If a D212-664-101/-201 or D412-664-203 Crosstube was stripped of paint, it should now be refinished as follows:

- 1) Apply chemical conversion film material (Alodine 1200 or 1201) per MIL-C-5541 and one coat of MIL-P-85582 or MIL-P-23377 primer.
- 2) Mask underside of crosstube as per hatched area shown in Figures 1 and 2 as applicable.
- 3) Paint outside surfaces of crosstube by applying 2-3 coats of MIL-C-85285 polyurethane paint to match original finish.
- 4) Apply clear coat on inspection window (hatched area).

Additionally, on D412-664-203 Aft Crosstubes at CHG 007 or later, the D2856-600-1009 Abrasion Strips have been removed, and D3189-1 Chafing Shields have been bonded onto the crosstubes using Proseal 890. For D412-664-203 Aft Crosstubes at CHG 007 or later, amend Parts List of IIN-D212-664 Section 5.1 and ICA-D212-664 Section 32.11.1 as follows:

Remove:

Item	QTY -203	Part Number	Description
31	2	* D2856-600-1009	ABRASION STRIP

If a D3189-1 Chafing Shield is being re-installed on the crosstube, it should now be re-installed as follows:

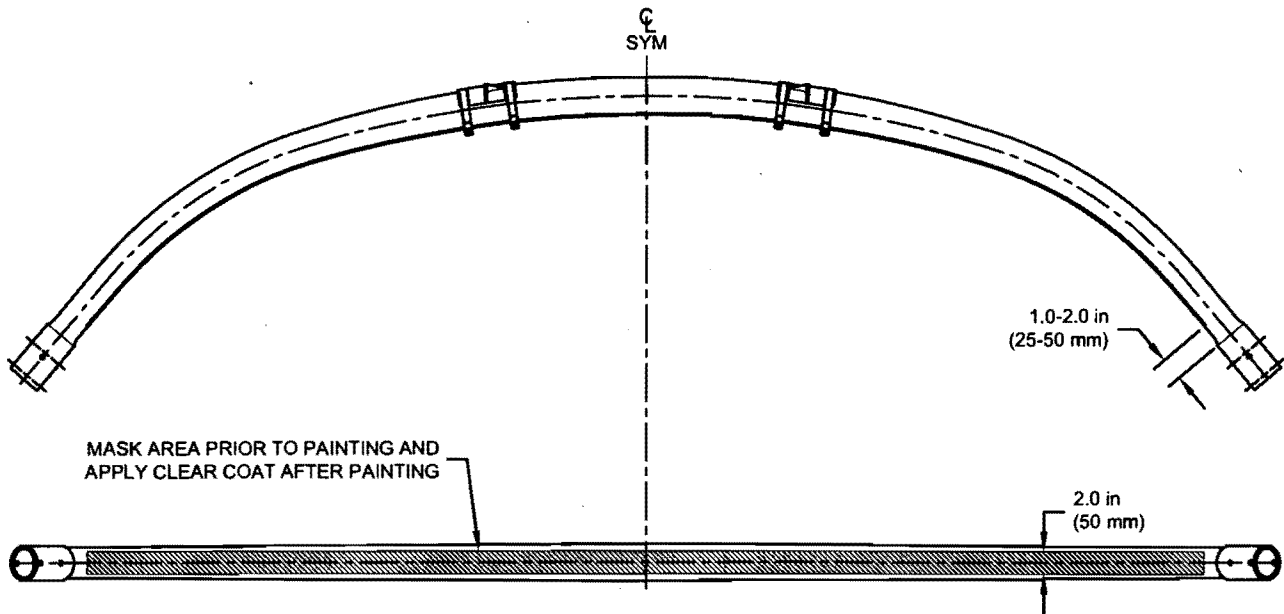
- 1) Follow section 32.1 of ICA-D212-664 for the removal of the crosstubes from the helicopter.
- 2) Remove the qty(2) MS21920-28 Clamps from the crosstube that fasten the D3189-1 Chafing Shields to the crosstube (ref. section 32.5 of ICA-D212-664).
- 3) Remove the D2856-600-1009 Abrasion Strip from the crosstube per section 32.7 of ICA-D212-664.
- 4) Inspect the crosstube surface where the chafing shields and abrasion strips were installed for corrosion and mechanical damage per items 5.3.1 and 5.3.2 of the 300 hour inspection. Repair damage within acceptable limits per item 5.3.3 of the 300 hour inspection. Touch up finish per item 5.3.9 of 300 hour inspection. If crosstube was stripped of paint, refer to instructions below for suitable refinishing of crosstube.
- 5) Apply a 0.02" to 0.04" (0.5-1.0 mm) thick layer of Proseal 890 on the concave surface of D3189-1 Chafing Shields and let cure per manufacturer's instructions.
- 6) Once the Proseal on the D3189-1 Chafing Shields is cured, apply a thin layer of Proseal 890 on the crosstube to cover the area where the Chafing Shields will be installed.
- 7) Locate the D3189-1 Chafing Shield as shown in Figure 3. Ensure that the overlapping edge of the chafing shield is located at approximately 60° from bottom vertical to prevent deterioration of the rubber bumpers. Be sure to eliminate any air gaps.
- 8) Position and tighten the clamps to a torque of 80-100 in-lb (9.0-11.3 N-m).
- 9) Allow the assembly to cure for 12 hours.
- 10) Re-install the D412-664-203 crosstube per section 32.2 of ICA-D212-664.

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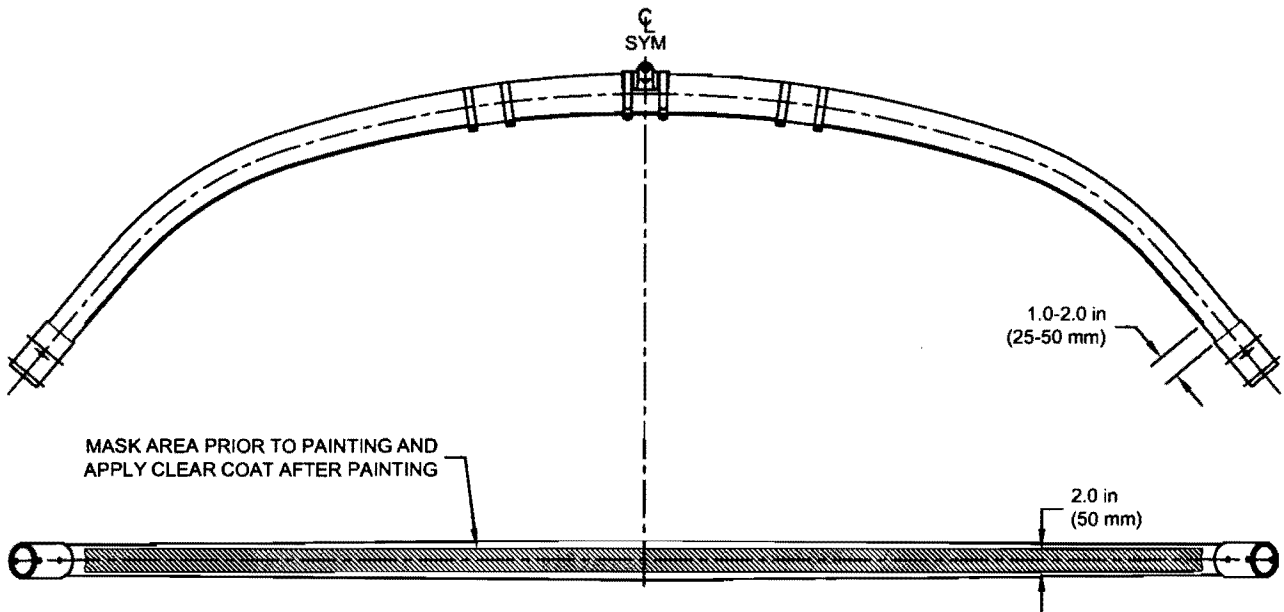
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BY:   
D. SHEPHERD (DE # 02)

DATE: 11.04.01  
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**FIGURE 1 - INSPECTION WINDOW ON  
D212-664-101/-201 CROSSTUBES**



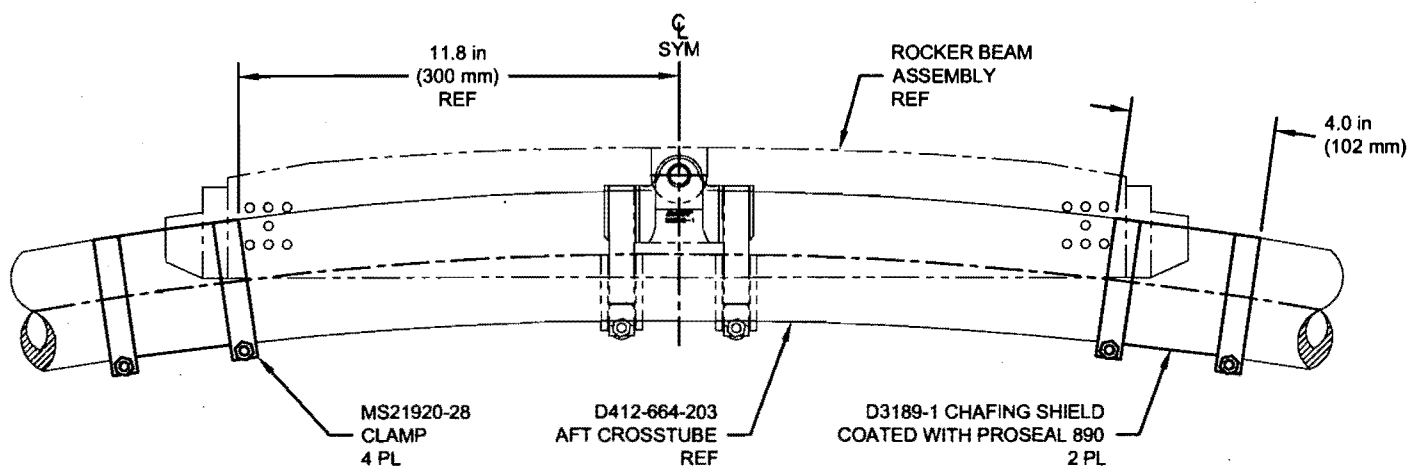
**FIGURE 2 - INSPECTION WINDOW ON  
D412-664-203 CROSSTUBES**

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**FIGURE 3 - CHAFING SHIELD  
INSTALLATION ON D412-664-203**

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